

Date: Monday, 12/5/2005 9:24:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B  
 Job Number : 25097  
 Estimate Number : 10163  
 P.O. Number : N/A Part Number : D206642241  
 This Issue : 12/5/2005 S.O. No. : Drawing Number : D2650 REV D1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 12/5/2005 Type : LANDING GEAR Drawing Revision : D1  
 Previous Run : 25086A Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 1/15/2006 Qty: 1 Um: Each  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

## Additional Product

DH

Rec'd P/wal 04/03/23 ① C.Y

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B24497 DP05-12-14 ①

2.0	D32861	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B24206 BE 06-01-03 ①

3.0	D2647	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B20535 BE 05-12-19 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP05-12-14-①

2- Remove ridge, on inside of Fwd edge of tube as per Dwg D2650 DP05-12-14①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action- Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 25097

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

- A/R Aluminum Rod *m15855 / m18901 BE 05-12-19 ①*
- 4-Grind weld flush to cap on top surface only. *BE 05-12-19 ①*
- 5-Cut Aft end as per dwg 2650 from front of tube and Deburr *DP 05-12-22 ①*
- 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 *BE 05-12-23 ①*
- 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. *BE 05-12-23 ①*
- 8-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. *BE 06-01-03 ①*
- 9- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. *BE 06-01-03 ①*
- 10-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. *BE 06-01-03 ①*
- 11-Remove and Deburr D3286-1 doubler *BE 06-01-03 ①*
- 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 *BE 06-01-03 ①*
- 13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder *BE 06-01-03 ①*
- 14-Remove indexing edge using DT8741 as per Dwg D2650 *DP 06-1-12 ①*
- 15-C'sink GHW rivet holes as per Dwg D2650

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 *BE 06-01-19 ①*
- 2-Drill pilot holes using DT8028-3 then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. *BE 06-01-19 ①*
- 3-Deburr tube and blow out chips from inside the tube *BE 06-01-19 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 25097

Part Number: D206642241

Job Number:



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7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *a.m 06-01-20 ①*

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Job 01-20 ①*

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid) *BE 06-01-20 ①*

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid) *BB 06-01-20 ①*

3-Deburr and blow out all chips from inside the tube *BE 06-01-20 ①*

10.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*Job 01-22*

11.0	CR3212404	Cherry Rivet
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Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch  
52 CR3212-4-04 Rivet *M18491*

*Pm 06-01-23*

*③*

12.0	D26543	206 I-Beam (Web)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2654-3 Web *B24418*

*Pm 06-01-24 ①*

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required *Pm 06-01-23 ①*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-01-24 Time: 9:15

Finish Date: 06-01-26 Time: 7:30

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m19597

Sikaflex expire date: 06-06-20

*pm 06-01-24*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-01-26*

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer *B 24200 BE 06-01-27*

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer *B 23932 BE 06-02-06 (1)*

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m15855 BE 06-01-27*

2-Grind welds flush as per Dwg D2650. *BE 06-02-01 (1)*

3-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr *pm 06-02-06 (1)*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. *BE 06-02-06 (1)*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

A/RSS Rod None

BE 06-02-06 (1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

m18548 pmc 06-02-07

(2)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

m7808 pmc 06-02-07

(2)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B21103 pmc 06-02-07

(1)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

pmc 06-02-07

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

06-02-08

PD 06-02-07

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

072 06/03/14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25097

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad B 24843

(5)

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe B 25329

(1)

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe B 20917

(1)

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe B 20213

(1)

29.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad B 24117

(1)

A. M 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25097

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 ALS4-1032-130 Inserts M18293

or (see QSI 017)

(44)

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 AN960JD10L Washer M19185

(44)

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 MS27039-1-08 Screw M16941

(44)

33.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-1 Plugs B25010

(18)

34.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2651-3 O-Rings A23491

(18)

A. M 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25097

Part Number: D206642241

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	MS27039406	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M15194

①

36.0	AN960JD416	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer M11151

①

A.M 06-03-22

37.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R / Sikaflex-291 M19597

Sikaflex expire date: 06-19-06

A.M 06-03-22

①

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

38.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

W

DL 06/03/23

①

39.0	D2646	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B22507

A.M 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 2/3/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M 16941

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M 19195

9. m 06-03-22

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M 19577

Sikaflex expire date: M 06-08-06

Q. m 06-03-22

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M 100037

FC 06 03 22

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

M DL 06/03/23 (1)

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/03/24

Job Completion



42 B Package per PPP

Job completion

14

06-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

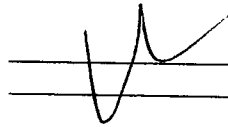
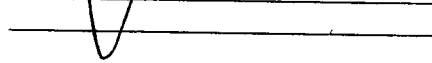
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Date: Thursday, 11/10/2007 2:26:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642
Job Number : 35132	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 11/10/2007 S.O. No. :	Drawing Number : ECN 1046-PAPERWORK
Prsht Rev. : NC	Project Number :
First Issue : // Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By : 	Due Date : 18/10/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 REMOVE FROM STOCK:

D206-642-111 15614 15615  
 D206-642-112 10319 25504  
 D206-642-141 9575 18613  
 D206-642-211 33078 32559-32565-33795-33776  
 D206-642-212 32257 32567-32566-32568-33079-33080-33242  
 D206-642-213 19735  
 D206-642-214 24414-24484-28083-29084-32983-32984  
 D206-642-241 28097-28604-33211-33342  
 D206-642-311 28847  
 D206-642-312 29741-15649-29742-29744  
 D206-642-341 x 24561-24562 x x x  
 D206-642-411 34555-34056-34555-34556-32495-31980  
 D206-642-411BL 34132 x x x x  
 D206-642-412 34564-34563-34562-34060-34059-32502-34058  
 D206-642-412BL 34735  
 D206-642-441 x 31066-30940-30260-30265-24739  
 D206-642-511 34502-34579-33848-34581  
 D206-642-512 34586-34584-34583- x  
 D206-642-513 \_\_\_\_\_  
 D206-642-514 \_\_\_\_\_  
 D206-642-541 \_\_\_\_\_  
 D206-642-611 \_\_\_\_\_  
 D206-642-612 \_\_\_\_\_

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1  
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